**In the Specification:**

Please replace the paragraph beginning at page 1, line 14, with the following rewritten paragraph:

-- It is particularly important in industrial use of machine tools that they run as free of disturbance as possible with low monitoring and maintenance demands. Any defects in the machine and/or disturbances during machining lead to undesired downtimes and even to demanding and cost-intensive repairs connected with economic loss from shutdown of the machine tool. A disturbance of a special type in this context is ~~undesireable~~ undesirable collision between the moving machine parts of the machine tool, for example, the tool or work table and the work piece being machined, as well as machine parts situated in their surroundings, like clamping devices to attach the work piece to the work table, parts of the work table itself or of the machine frame, devices to supply current to the work zone, rinsing agents, devices for smoke and dust removal, protruding parts of the work piece being machined or work pieces already machined on a pallet, especially ~~reject~~ drop-out pieces. The mentioned clamping devices are particularly critical and restrictive for motion freedom of the tool. Depending on the size and number of work pieces clamped in the work zone, differently shaped clamping devices in different numbers are arranged in the work zone and all are not fully examinable by the operating personnel, for which reason collisions can occur from incorrect operation in manual operation or incorrect programming in automatic operation. --

A1

Please replace the paragraph beginning at page 9, line 23, with the following rewritten paragraph:

--Figure 1 shows a schematic view of the X/Y/Z axial drive system of a ~~cavity~~ die sinking machine with the measurement system constructed in accordance with the teachings of the invention.--

A2

Please replace the paragraph beginning at page 10, line 30, with the following rewritten paragraph:

--Each of the X/Y/Z drive systems has its own axial control unit, namely an axial control unit 28 for the X drive, an axial control unit 29 for the Y drive and an axial control unit 30 for the Z drive, which control the advance movement of the cavity-sinking electrode 10 that determines the sinking contour and optionally a relative movement in the X/Y plane between the cavity-sinking electrode 10 and the work piece 20, necessary for cavity-sinking machining of work piece 20. For this purpose, the X, Y and Z axial control units 28, 29 and 30 issue the corresponding position signals to the servomotors 12, 22, 24. The position data for generation of the

A3

X, Y and Z adjustment signals are obtained from the axial control units 28, 29 and 30 of a central computerized numerical control (CNC) unit 60 of the cavity-sinking machine. The programmed path and contour data or the data obtained from a superordinate computer are preferably subjected in the CNC control unit 60 to fine interpolation and optionally a path correction procedure and then issued in the form of position signals $X_{pos}$, $Y_{pos}$ and $Z_{pos}$ to the corresponding X, Y and Z axial control units 28, 29 and 30. The CNC control unit 60 of the cavity-sinking machine is also connected to a generator and process control unit 61, which controls the actual machining conditions such as machining current, machining voltage, pulse pause times and rinsing. From these quantities the CNC control unit 60 produces the actual path speed and advance speed data, which are sent as speed signals $V_X$, $V_Y$ and $V_Z$ to the corresponding axial control units 28, 29 and 30 for position and speed control.--